Each

6 Um:

: 90 DEGREE BLADE SUPPORT ASSY

: PB674300167

: 15/09/2008

: N/A

: B1

: B6743001 PAGE24

Wednesday, 13/08/2008 10:55:31 AM

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer : CU-DAR001 Dart Helicopters Services

Job Number : 41214 **Estimate Number** : 13386

P.O. Number

Prsht Rev.

This Issue

: 13/08/2008 S.O. No. :

: NC

: 11 First Issue

: SMALL /MED FAB Type

: 40243 Previous Run

Checked & Approved By

Comment

Written By

: Est Rev:A 08-06-19 new issue DD verified by:ec

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description: 6061-T6 .090 Sheet

M6061T6S090 1.0

Comment: Qty.: 0.6241 sf(s)/Unit Total: 3.7447 sf(s)

6061-T6 .090 Sheet

batch: 108595

WATER JET 2.0

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg B67-43001-147 Dwg Rev: 8

Prog Rev: B)

2-Deburr if necessary

3.0 .





Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SECOND CHECK



Comment: SECOND

SMALL FAB 1



Comment: Form as per dwg B67-43001





Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES							
DATE	STEP PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
	7								
	17		į.						
Part No		PAR #: Fault Category:	NC	D. Vos	No DO	۸.	Date	42	

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
			QA: N/C Closed:	Date:
NCR:		WORK ORDER NON-COM	NFORMANCE (NCR)	

NCR:		Wo	ORK OR	DER NON-CONFORMANO	CE (NCR)			
		Description of NC	Corrective Action Section B			Verification		
DATE	STEP	Section A		Initial Action Description Sign & Chief Eng Date		Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Wednesday, 13/08/2008 10:55:31 AM 'User: , Julie Lecocq **Process Sheet** Drawing Name: 90 DEGREE BLADE SUPPORT ASSY Customer: CU-DAR001 Dart Helicopters Services Part Number: PB674300167 Job Number: 41214 Job Number: Seq. #: Description: Machine Or Operation: 6.0 QC5 INSPECT WORK TO CURRENT STEP Comment: INSPECT WORK TO CURRENT STEP 7.0 PB6743001149 Side Plate Comment: Qty.: 2.0000 Each(s)/Unit Total: 12.0000 Each(s) Side Plate 34/231 = 108.0 Comment: Weld assembly as per dwg B67-43001 VISUAL WELDING INSPECTION 9.0 QC9 PD 04-09-24 18 Comment: VISUAL WELDING INSPECTION INSPECT WORK TO CURRENT STEP 10.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 HAND FINISHING1 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION MS21075L3 Comment: Qty.: 6.0000 Each(s)/Unit Total: 36.0000 Each(s) M 10 9068 Nutplate MS20426AD34 RIVET 14.0 Comment: Qty.: 12.0000 Each(s)/Unit Total: 72.0000 Each(s) RIVET

Page 2

Form: rprocess

Dart Ae	rospace L	td		7					
W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	TEP PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
						- 4			
						Ř			
						6			
Part No	:	PAR #:	Fault Categ	jory:	NCR: Yes	No DQA	A:	_ Date: _	
							l:	_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCR)			
DATE	CTED	Description of NC Corrective Action			NEW TOWNS OF THE PARTY OF THE P		ation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section		Chief Eng	QC Inspector
		3							

NOTE: Date & initial all entries

Date: User:

Wednesday, 13/08/2008 10:55:31 AM

Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE BLADE SUPPORT ASSY

Job Number: 41214

Part Number: PB674300167

Job Number:



Seq. #:

Machine Or Operation:

Description:

15.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1

Comment: Assemble as per dwg B67-43001

16.0

QC5

INSPECT WORK TO CURREN



Comment: INSPECT WORK TO CURRENT STEP

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock Location: 346

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

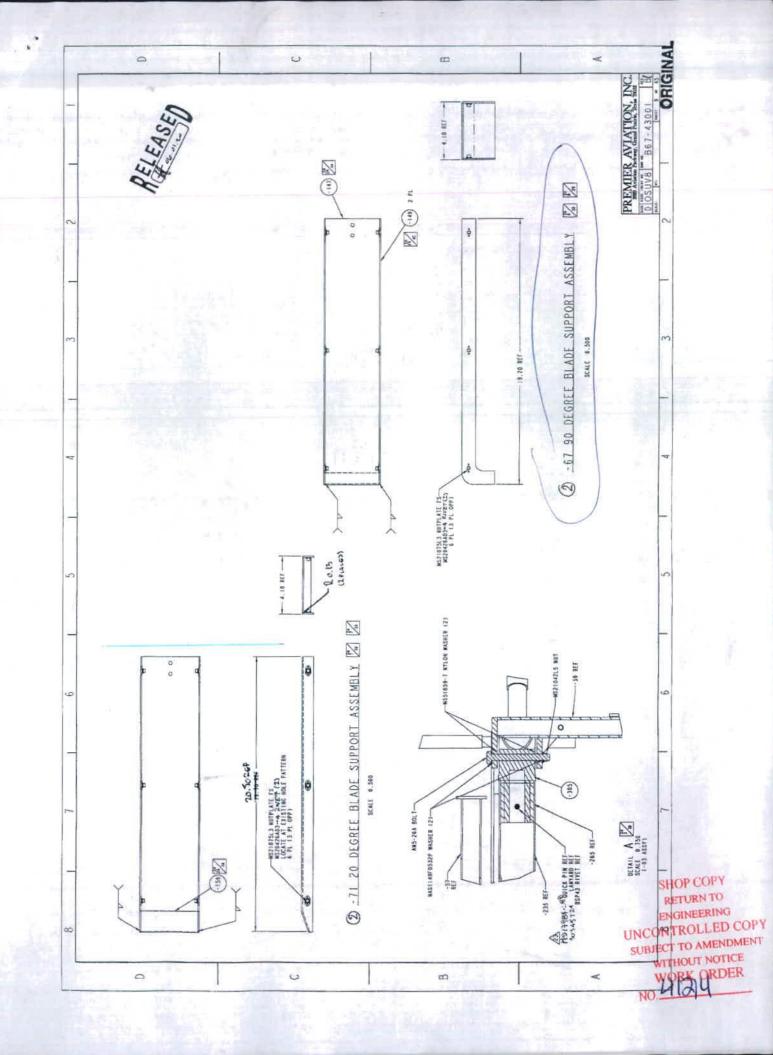
Job Completion



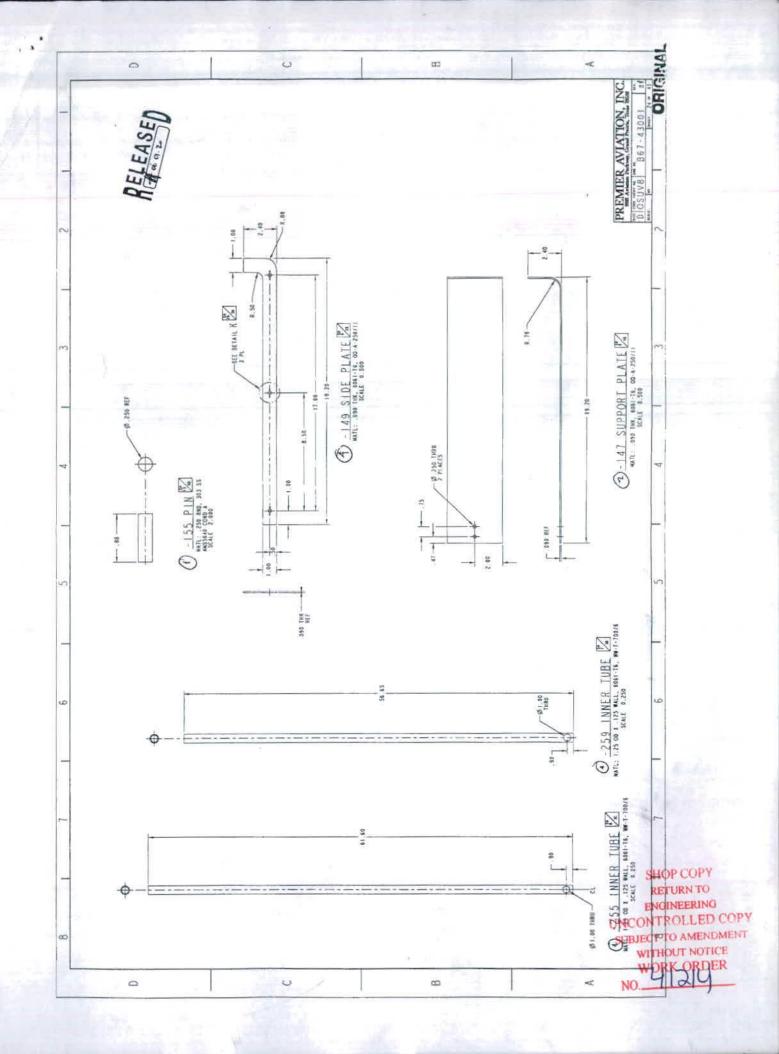
Dart Ae	rospace L	_td						
W/O:			WC	RK ORDER CHANGE	S			
DATE	STEP	PRO	PROCEDURE CHANGE			Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	Jory:		lo DQA:		
NCR:			WORK ORDE	R NON-CONFORMAN				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NCK.			TOTAL ORDER HOLL OR MINISTEE (HOLL)						
		Description of NC	Corrective Action Section B			Verification	A	Ammunusi	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector	

NOTE: Date & initial all entries







		4

DART AEROSPACE LTD	Work Order:	41244
Description: 90 BLADE SUPPORT ASSY	Part Number:	PB 674 3001-147
Inspection Dwg: Rev: RI	100	Page 1 of 1

PB 6743001-147 FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	le X	Proto	type	
Drawing Dimension	Tolerance	Actual Dimension	Accept	Rejest	Method of Inspection	Comments
\$.250	+ .005-001	.251				
.47	4 .030	.410				(4)
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Measured by:	rk.	Audited by:	Prototype Approval:	1	/_
Date:	29.2	Date: 08/08/64	Date:	./	1

	Rev	Date	Change	Revised by	Approved
-	Δ		New Issue	KJ/JLM	
	7		11011 10000	-	



